

Work Order ID 101987

May-22-13 10:50:07 AM

101987

Page 1

Item ID: D4769-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearplate Assembly

Start Date: 5/22/13

Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/24/13

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: W

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4769

A

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

② Q 13-5-28

120

0.00

120

Large Fab

Memo

0.00

Large Fab

1- Weld hardcoat on bars as per dwg

A/R 2059b hardcoat Batch#: M 124842

2- Weld bar to wearplate as per dwg

A/R s.s. rod Batch #: M 122357

3- Weld shim as per dwg

A/R s.s. rod Batch #:

4- Transfer drill drain holes as per dwg

② Q 13-5-28

Work Order ID 101987

101987

Page 2

May-22-13 10:50:07 AM

Item ID: D4769-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 5/22/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/24/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---------------------|
| 130 *130* QC Quality Control | QC9- Inspect visual per QSI004- Fusion Welds Memo | 0.00 0.00 | | | | ② | 305.30 | | (DAS) 09 9-89 |
| 140 *140* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | ② | 305.30 | | (DAS) 09 9-89 |
| 150 *150* Small Fab Small Fab | Memo Apply Rockguard on entire concave surface as per dwg A/R Rockguard Batch: 125226 | 0.00 0.00 | | | | 2 | 0 | 0 | As 13-5-31 |

Work Order ID 101987

101987

Page 3

May-22-13 10:50:07 AM

Item ID: D4769-041 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate Assembly
 Start Date: 5/22/13 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 5/24/13 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 160 *160* QC Quality Control | QC5- Inspect part completeness to step on W/O Memo | 0.00 0.00 | | | | 2 | | | |
| 170 *170* Packaging Packaging | Identify as per dwg & Stock Location: <u>FP-001</u> Memo | 0.00 0.00 | | | | | | | |
| 180 *180* QC Quality Control | QC21- Final Inspection - Work Order Release Memo | 0.00 0.00 | | | | | | | |

2x — 4 — 13/06/07

MLJ 13-06-05

13-06-04

Picklist Print

May-22-13 10:50:06 AM

Page 1

Work Order ID: 101987

Parent Item: D4769-041

Parent Item Name: Wearplate Assembly

Start Date: 5/22/13

Required Date: 5/24/13

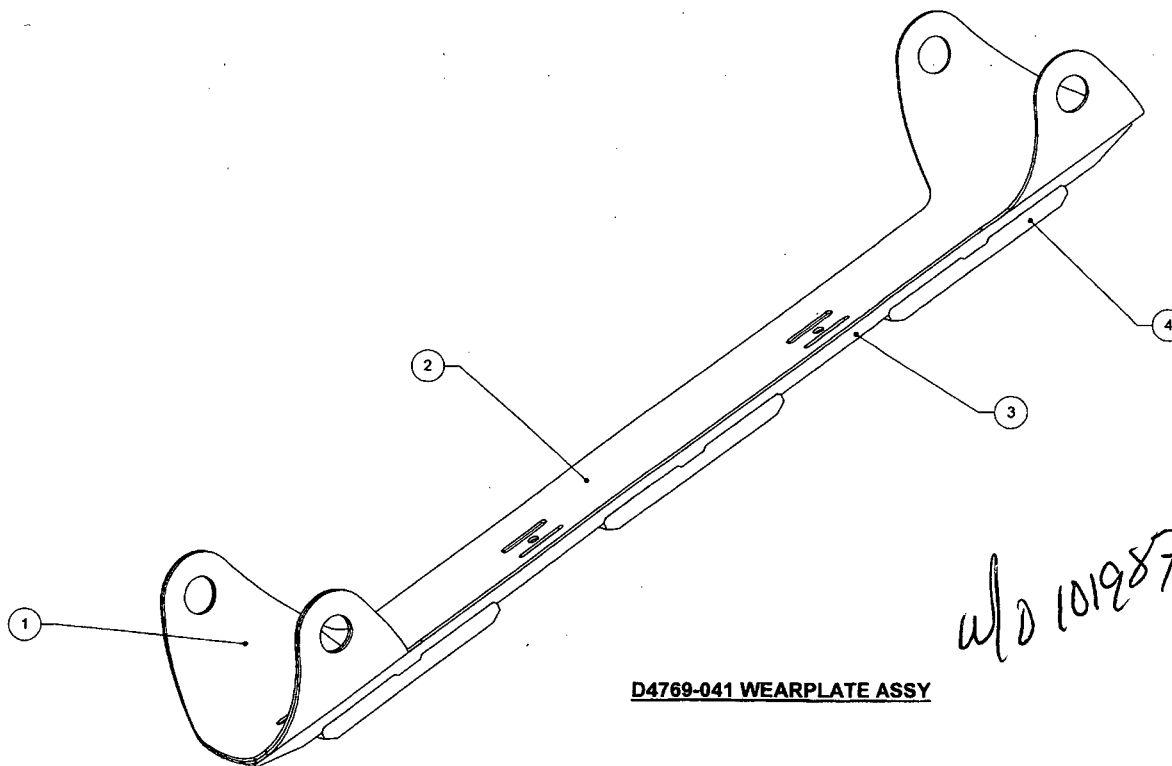
Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.03.27 NEW ISSUE DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| D4682-9 Wearplate Shim | | Manufactured | No | B100 608 x 2 | | | Each | 0.0000 | | 2 EL 13-5-28 | | | |
| D4769-1 Wearplate | | Manufactured | No | B101 993 x 2 | | | Each | 0.0000 | | 2 EL 13-5-28 | | | |
| D4770-1 Bar | | Manufactured | No | 101990 x 4. | | | Each | 0.0000 | | 4 EL 13-5-28 | | | |

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|-----------|----------------|
| | X | D4769-041 | WEARPLATE ASSY |
| 1 | 1 | D4682-9 | WEARPLATE SHIM |
| 2 | 1 | D4769-1 | WEARPLATE |
| 3 | 2 | D4770-1 | BAR |
| 4 | A/R | 2059B | HARDCOAT WELD |



D4769-041 WEARPLATE ASSY

w/o 101987

RELEASED
2013-03-25
W/O

| | | | | | |
|------------|--------------------|--|--|---|----------|
| A | | NEW ISSUE | | AP | 13.02.13 |
| REV. | DESCRIPTION | | | BY | DATE |
| DESIGN | DB | DART AEROSPACE USA, INC. KENT, WA DRAWING NO. D4769 TITLE WEARPLATE ASSY SCALE NTS | | REV. A | |
| DRAWN | AP | | | SHEET 1 OF 4 | |
| CHECKED | <i>[Signature]</i> | | | | |
| MFG. APPR. | <i>[Signature]</i> | | | | |
| APPROVED | <i>[Signature]</i> | | | | |
| DE APPR. | <i>[Signature]</i> | | | | |
| DATE | 13.02.13 | | | <small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

D4682-9 WEARPLATE SHIM

TYP

10

11 9

11 9

SECTION B-B C4-2
SCALE 1X

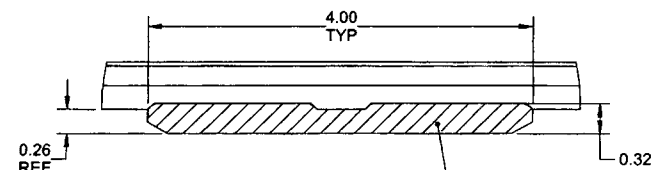
2059B HARDCOAT

C7-2 B

D4769-1 WEARPLATE

A B7-2

D4770-1 BAR





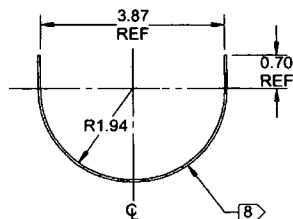
DETAIL A C3-2 6 PL
SCALE 2X

D4769-041 WEARPLATE ASSY

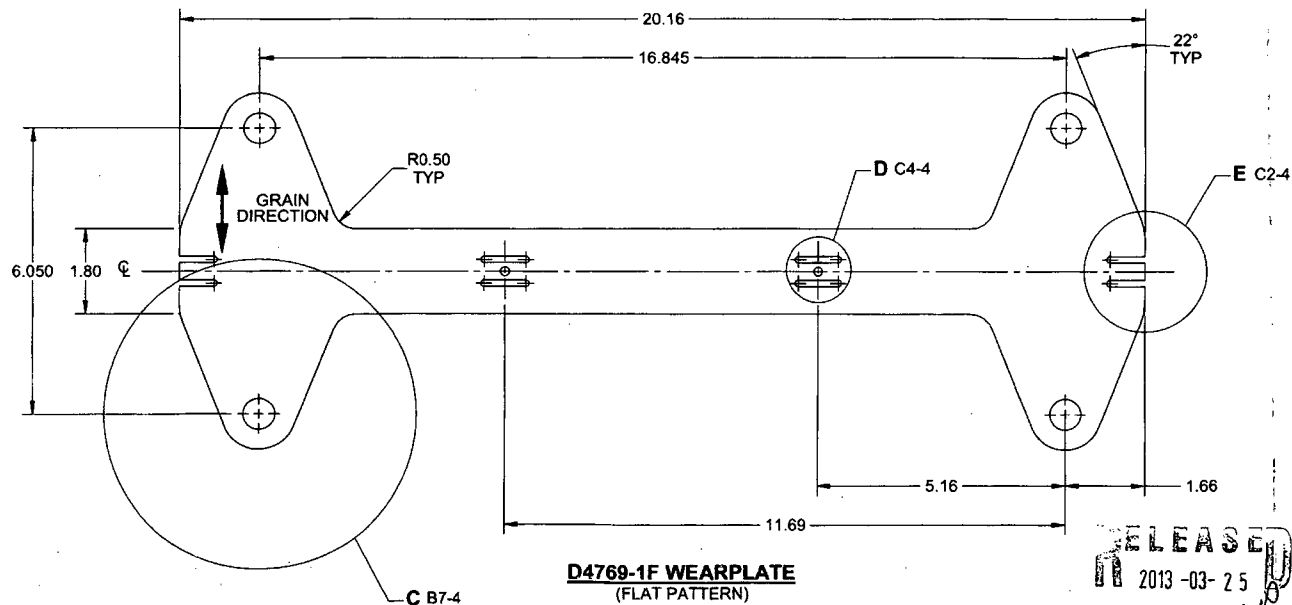
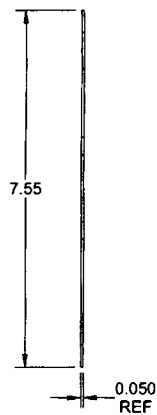
- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4769-041" AND B/N PER QSI 044 METHOD 6.1
 - 7) WEIGHT: 4.79 lbs
 - 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-1 BAR ON LATERAL SURFACES, 6 PL
 - 9) TRANSFER DRILL $\varnothing 0.188$ HOLE FROM D4769-1 WEARPLATE TO D4770-1 BAR
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF PLUS ONE ROCKGUARD 4714, 0.020 - 0.040 THICK
 - 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING PLUS ONE ROCKGUARD

RELEASED
2013-03-25

| | | | |
|------------|---|---|--------------|
| DESIGN | DB | DART AEROSPACE USA, INC. | |
| DRAWN | AP | KENT, WA | |
| CHECKED |  | DRAWING NO. D4769 | REV. A |
| MFG. APPR. |  | | SHEET 2 OF 4 |
| APPROVED |  | TITLE WEARPLATE ASSY | SCALE NTS |
| DE APPR. |  | | |
| DATE | 13.02.13 | <small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |



D4769-1 WEARPLATE
(MAKE FROM D4769-1F)



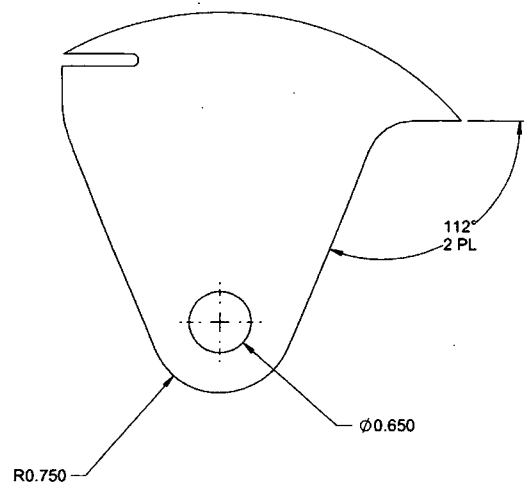
D4769-1F WEARPLATE
(FLAT PATTERN)

RELEASED
2013-03-25

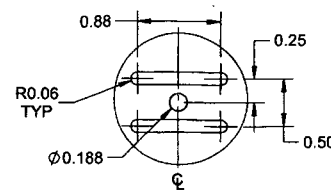
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.85 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4769-1 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

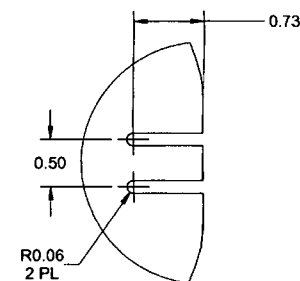
| | | | |
|------------|----------|---|--------------|
| DESIGN | DB | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | AP | | |
| CHECKED | | DRAWING NO. D4769 | REV. A |
| MFG. APPR. | | | SHEET 3 OF 4 |
| APPROVED | | TITLE WEARPLATE ASSY | SCALE |
| DE APPR. | | | NTS |
| DATE | 13.02.13 | <small>COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |



DETAIL C B5-3
4 PL
SCALE 2X



DETAIL D B3-3
2 PL
SCALE 2X



DETAIL E B1-3
2 PL
SCALE 2X

RELEASED
2013-03-25

| | | | |
|------------|----|---|--------------|
| DESIGN | DB | DART AEROSPACE USA, INC. KENT, WA | |
| DRAWN | AP | | |
| CHECKED | AP | DRAWING NO. D4769 | REV. A |
| MFG. APPR. | AP | SHEET 4 OF 4 | |
| APPROVED | AP | TITLE WEARPLATE ASSY | SCALE NTS |
| DE APPR. | AP | DATE 13.02.13 | |

COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.